

PIPING SYSTEMS

INTRODUCTION

This chapter defines procedures for designing, fabricating and testing piping systems.

SCOPE

This chapter applies to all piping systems fabricated and/or operated at Fermilab.

DEFINITIONS

Engineering Note: A written analysis demonstrating that a given piping system satisfies the requirements of this chapter.

Qualified Person: A qualified person is a person who, by possession of a recognized degree or certificate of professional standing, or who, by extensive knowledge, training and experience, has successfully demonstrated the ability to solve or resolve problems relating to the subject matter and work.

Radioactive Water (RAW) System: Water systems containing radioactive water as defined in FRCM (Fermilab Radiological Control Manual) Article 346.

Appropriate Governing Code: A national, state or local piping code or standard that specifies design, fabrication, and operation requirements and practices that must be followed for piping systems within their respective scopes.

Exceptional Piping System: A piping system which cannot meet the requirements of this chapter and therefore requires a Director's exception.

SPECIAL RESPONSIBILITIES

The Division/Section Head who controls the area of operation of the piping system is responsible for carrying out the requirements of this chapter. The Division/Section Head, or designee, shall arrange for the review of required Engineering Notes by a qualified person and shall certify piping systems compliance with this chapter by signing the Engineering Notes. The original Engineering Notes shall be placed into the Laboratory Piping Systems master file maintained by the ES&H Section.

The ES&H Section shall audit the Divisions and Sections on their compliance to this chapter.

The Mechanical Safety Subcommittee shall serve the Division/Section Heads and ES&H Section in a consulting capacity on all piping system matters. This includes providing recommendations regarding the applicability of a standard to a given piping system. The Mechanical Safety Subcommittee may propose appropriate modifications to this chapter as necessary. Changes in policy and responsibility shall be recommended by the Laboratory Safety Committee after consulting with the Division/Section Heads.

POLICY AND REQUIREMENTS

1. *Policy:* All piping systems built and/or operated at Fermilab shall be in accordance with this chapter and the appropriate governing code. See Table 1 for guidance in the selection of the appropriate governing code for common piping systems operated at Fermilab. Note that the recommendations given in Table 1 are general. Evaluation of each specific piping system (operating parameters, fluid type, environment, etc.) is necessary to determine the appropriate governing code and category.
 - a. When an appropriate governing code cannot be identified for a particular piping system or a when a piping system falls outside the scope of the appropriate governing code, accepted engineering practice (commensurate with the piping system parameters and risk factors) shall be employed. The piping system in question is still subject to the remaining requirements of this chapter.
 - b. Where multiple codes apply, accepted engineering judgment shall determine the most appropriate code considering the hazards and risks of the individual piping system. At a minimum, ASME B31 piping code series will govern for those piping systems within their respective scopes.
2. *Documentation:* An Engineering Note shall be prepared by a qualified person for all piping systems identified below (2.a), whether purchased or in-house built. The format of the Engineering Note is shown in the Technical Appendix (5031.1TA). Its purpose is to allow a reviewer to check the design and installation and to inform a future user of the piping system's parameters. The document shall include design calculations for the piping systems and manufacturer's compliance to the appropriate governing code for purchased piping systems. All code-required documentation shall be appended to the document including welding/brazing qualification records and inspection/examination records. The document shall also include precautions, diagrams, documents and operation procedures necessary for the safe use of the piping system.
 - a. An Engineering Note must be prepared, reviewed, and approved when:
 - i. The piping system contains over 150,000 ft-lbs of stored energy or the operating pressure is above 150 psi for gas, or 500 psi for liquid, or the design operating temperature is above 366° F. (Excluding those piping systems

temporarily erected for pressure testing purposes. These systems are subject to FESHM Chapter 5034.)

- ii. The piping system falls within the scope of ASME B31.3 Process Piping Code – Normal Fluid Service (excluding those piping systems containing only water).
 - iii. The piping system is a hydraulic (oil) piping system (primarily hydrostatic; not used for transport of the fluid) with a design operating pressure above 10,000 psi.
 - iv. The piping system falls within the scope of ASME B31.3 Process Piping Code – Category M.
 - v. The piping system has the potential for an environmental release exceeding the occurrence reporting criteria of FESHM 3010. This includes RAW cooling systems.
 - vi. The piping system is an Exceptional Piping System.
- b. Piping systems that do not require Engineering Notes are still required to satisfy the appropriate governing code. In these cases, all code-required documentation shall be kept on file by the responsible engineer or Department Head (or their designee).
6. *Review of piping systems:* All required Engineering Notes (see 2.a above) shall be reviewed by an independent, qualified reviewer, other than the person who prepared it, for concurrence to this chapter. The review of the Engineering Note shall include review of code-required installation documentation to ensure conformance of the installation to the appropriate governing code.
7. *Piping Systems with Additional FESHM Chapter Requirements:* Some piping systems must comply with more stringent safety analyses. Additional Fermilab ES&H chapters have been written for these specific systems. The documentation and review requirements for these systems are included in the following chapters:
- a. Any flammable gas system covered and reviewed under Fermilab ES&H Manual Chapter 6020.3.
 - b. Any cryogenic system covered and reviewed under Fermilab ES&H Manual Chapter 5032.
8. *Modifications to a compliant piping system:* Any subsequent changes in usage or operation of a piping system (already in compliance with this chapter) shall meet the requirements of this chapter. Significant modifications impacting piping system

safety shall be documented in a reviewed Amendment to the original Engineering Note (for those systems requiring Engineering Notes).

9. *Director's Exception:* Exception to the provisions of this chapter shall be allowed only with the signature of the Laboratory Director or his designee and documented in the Engineering Note. The need for such exceptions is to be minimized by adherence to the provisions of this chapter. Exceptions are to be identified and submitted to the Director for review as early in the design process as possible. These exceptions shall only be allowed after the Director is assured that sound engineering practice will be followed during design, fabrication and test of the piping system. The ES&H Section shall maintain copies of exceptions for the Director.

PROCEDURES AND REQUIREMENTS FOR DESIGN, FABRICATION, INSPECTION AND TEST

1. *Purchased Piping Systems:* All piping systems purchased by Fermilab or its experimenters shall be made (designed and fabricated) in accordance with this chapter.
2. *In-House Built Piping Systems:* All pressure piping systems built at Fermilab or experimenter's shops shall be designed and fabricated in accordance with this chapter. Welding/brazing executed at Fermilab shall be done in accordance with the appropriate governing code requirements including applicable welding qualification and inspection/examination requirements. When an appropriate governing code cannot be identified for a particular piping system or when a piping system falls outside the scope of the appropriate governing code, accepted welding/brazing fabrication procedures (commensurate with the piping system parameters and risk factors) shall be employed.
3. *Existing Piping Systems In Service:* All such piping systems must be in accordance with this chapter. Questionable existing piping systems or those with unknown histories shall be reviewed and documented in accordance with this chapter except that they may be retested per the *Leak Test* section of this chapter (see 5 below) in lieu of detailed welding qualification records and non-visual examination/inspection records. Acceptance of this substitution is subject to the reviewer's discretion.
4. *Used Piping Systems:* Used piping systems shall be classified as an existing piping system and will have their previous service taken into account during the review process.

5. *Leak Test:* All piping systems shall be pressure tested as required by the appropriate governing code. When an appropriate governing code cannot be identified for a particular piping system or when a piping system falls outside the scope of the appropriate governing code, accepted engineering practice (commensurate with the piping system parameters and risk factors) shall determine leak test requirements.
 - a. The initial service test is considered the pressure test for ASME B31.3 Category D piping systems. No safety officer oversight per FESHM 5034 is required for pressure testing piping systems in this category.
 - b. Internally pressurized tests as described in ASME B31 Codes for externally pressurized pipe are not required for ASME B31.3 Category D and B31.9 vacuum jackets and vacuum piping. Standard sensitive leak tests using tracer gases satisfy the leak test requirements of this chapter. No safety officer oversight per FESHM 5034 is required for these tests.
 - c. All other piping systems requiring leak tests shall be pressure tested as described per Fermilab ES&H Manual Chapter 5034. In case of conflicts between the appropriate governing code and Chapter 5034, the more restrictive or conservative procedure will be followed.
6. *Component Identification:* Components on piping systems shall be labeled as required by the appropriate governing code. In addition, it is recommended that components on all piping systems that require Engineering Notes be labeled to correspond to an up-to-date piping and instrument diagram. Labels should be permanent, securely attached and easy to read. Each component label should list a unique component number for that system. Guidance may be obtained from ANSI A13.1 "Scheme for Identification of Piping Systems".

Piping Service or Application	Applicable Code or National Standard										
	ASME B31.1	ASME B31.3 Normal Fluid Service	ASME B31.3 Cat. D Fluid Service	ASME B31.5	ASME B31.8	ASME B31.9	NFPA 13	NFPA 24	ASME A17.1	ANSI Z223.1	Illinois Plumbing Code, Title 77 Part 890
Building Sump Pump Discharge						X					
Compressed air/inert gas						X					
Cryogenic Liquid or Gas		X									
Domestic Potable Water											X
Elevator and Lift Hydraulic Systems									X		
Fire Protection							X				
Flammable Gas		X									
Fuel Gas Transmission Piping					X						
Fuel Gas Piping from point of delivery to burner										X	
House Vacuum						X					
Industrial Cooling Water internal to buildings						X					
Industrial Cooling Water external to buildings								X			
Inner Pipe of Vacuum Insulated Cryogenic Piping		X									
Low Conductivity Water		X	X								
Pond Water Cooling Systems						X					
Radioactive Water		X									
Refrigerant for Process Systems		X									
Refrigerant for HVAC				X							
Sewer Piping											X
Steam for Heating Applications						X					
Steam for Power Generation	X										
Vacuum Jacket of vacuum insulated piping			X								

Table 1: Applicable code guidance for common systems at Fermilab

TECHNICAL APPENDIX TO PIPING SYSTEMS

ENGINEERING NOTE

1. Engineering Note: An Engineering Note shall be prepared by the designer addressing the topics below for the piping system. Its purpose is to allow the reviewer to check the design and installation and to inform the future user / re-tester of the system parameters. The note shall be signed and deposited as noted in Chapter 5031.1 under "Special Responsibilities".
2. Description and Identification: Obtain a piping identification number from the ES&H Section at x5555 or esh_admin@fnal.gov. Describe the system, its purpose, fluid contents, piping materials, site location, and how the design pressure and temperature were established. All documents deemed pertinent to the safety shall be listed and included.
3. Design Verification: Identify the applicable Code and provide design calculations.
4. Pressure Containment / Relief System: If required, describe any system features which prevent design pressure from being exceeded.
5. Welding / Brazing Information: Welding / brazing executed at Fermilab shall be done in a manner according to the Code. In-house procedures shall be appended to the Note for welded and brazed systems built at Fermilab. Purchased systems shall be welded according to the Code. (Weld procedures for purchased piping systems need not be included in the Engineering Note but should be provided by the contractor to the Inspector if requested.)
6. Welder's Qualification: Attach welder's qualification records if welded / brazed in-house.
7. Inspection Plan: Attach a copy of the system's inspection plan.
8. Examiner's Report: Attach a copy of Examiner's report.
9. Inspector's Certification: Attach a copy of Inspector's certification of this system.
10. Component Identification: Attach the Process and Instrumentation Diagram (PID) and the associated component and instrumentation list.
11. Leak Test: Attach a copy of the leak test plan, including test pressure, and results, if available, at the time of review. The test permit and test results should be appended to the approved Note as soon as they become available.

12. Extended Engineering Note for Exceptional Piping Systems: In addition to the items listed above, the Note shall include the following information:

- a. *Reason for Exception*: Division / Section Head or designee shall provide a statement showing the necessity for a Director's exception.
- b. *Exception Protocol*: The Division / Section Head or designee shall provide a written record of the decisions, judgment, tests, administrative controls, and hazard analysis that were necessary to approve this type of system.
- c. *Proof Test*: Proof tests of unlisted components in the system shall be performed in accordance with ASME BPV Code Section VIII, Division 1, UG-101 or ASME B16.9.
- d. *Fabrication*: The system designer shall provide a fabrication procedure, a list of planned and completed inspections and any other quality control procedures taken.
- e. *What-if Analysis*: The system designer shall provide a description of personnel hazards associated with system operation and the methods used for protection. The What-if Analysis shall address application, operating limits and controls, possible effects in the event of failure and inherent safeguards provided.